

Work Order ID 71442

Monday, July 04, 2011 1:04:22 PM



Page 1

Item ID: D4154-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate Assembly

Start Date: 7/5/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: UMF

Date: 11-07-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4154

B

100

0.00



Large Fab

Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

DT9756

2059 B Hardcoat Welding Rod

BATCH# M118796

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod,

BATCH # M117659

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10 11-04-08 JBL/EZ

11.08.04 (10)

David D

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Suloslay

(XLO)

150



Small Fab

Small Fab

Memo

1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3
dwg D4154.

0.00

0.00

11/08/11

M118000

10

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Suloslay

(XLO)

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Cust Item ID:

Required Date: 7/19/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

Identify as per dwg & Stock Location: FP-1

0.00



Packaging

Memo

0.00

Packaging

10 of HL 4108115

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/15

11-08-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1
T

Work Order ID: 71442



Parent Item: D4154-041



Parent Item Name: Wearplate Assembly

Start Date: 7/5/2011

Required Date: 7/19/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC
10.11.04 added DT9684 DD verf:EC
per dwg revB DD verf:EC

IPP Rev:B
IPP Rev:C 11.04.14 as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1 Plate		Manufactured	No			100	Each	1.0000	1	8			
	71444 x 8 69811 x 2									8		11-07-28 JBC/EL	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		1							
					66312	1							
D4155-1 Bar		Manufactured	No			100	Each	6.0000	1	8			
	71443 x 8 69810 x 2									8		11-07-28 JBC/EL	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
					69810	6							

W/O:		WORK ORDER CHANGES					
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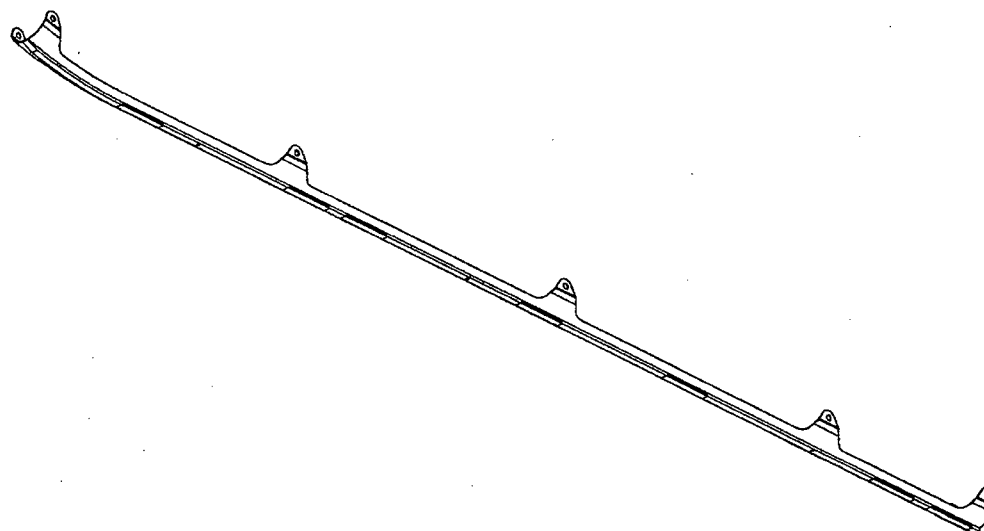
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4154-041	WEARPLATE ASSEMBLY
1	1	D4154-1	PLATE
2	1	D4155-1	BAR
3	A/R	2059B	HARDCOAT
4	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2)



D4154-041 WEARPLATE ASSEMBLY

71440

RELEASED
2011-04-10
WMD

B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F		MB	11.04.05
A	NEW ISSUE		SC	10.07.22
REV.	DESCRIPTION		BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.		
DRAWN	h	PORT HADLOCK, WA		
CHECKED	W	DRAWING NO.	REV. B	
MFG. APPR.	W	D4154	SHEET 1 OF 3	
APPROVED	W	TITLE	SCALE	
DE APPR.	W	WEARPLATE ASSEMBLY	NTS	
DATE	11.04.05	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>		

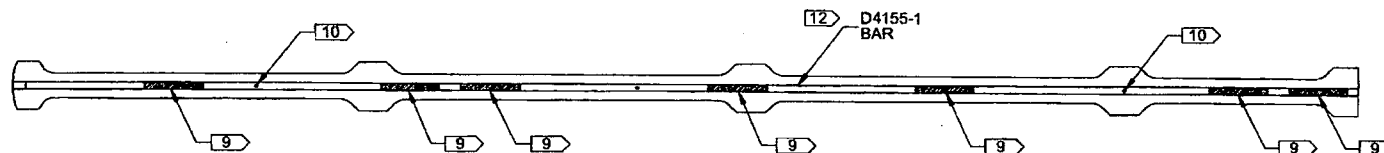
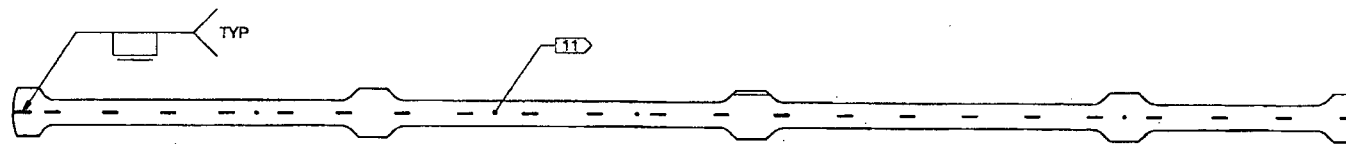
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D4154-041 WEARPLATE ASSEMBLY

RELEASED
2011-04-13

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D4154-041" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 6.88 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D4154-1 BAR ON ALL 3 SURFACES AT 7 PLACES
- 10) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	5	PORT HADLOCK, WA	
CHECKED	2	DRAWING NO.	REV. B
MFG. APPR.	11/04/05	D4154	SHEET 2 OF 3
APPROVED	11/04/05	TITLE	SCALE
DE APPR.	11/04/05	WEARPLATE ASSEMBLY	NTS
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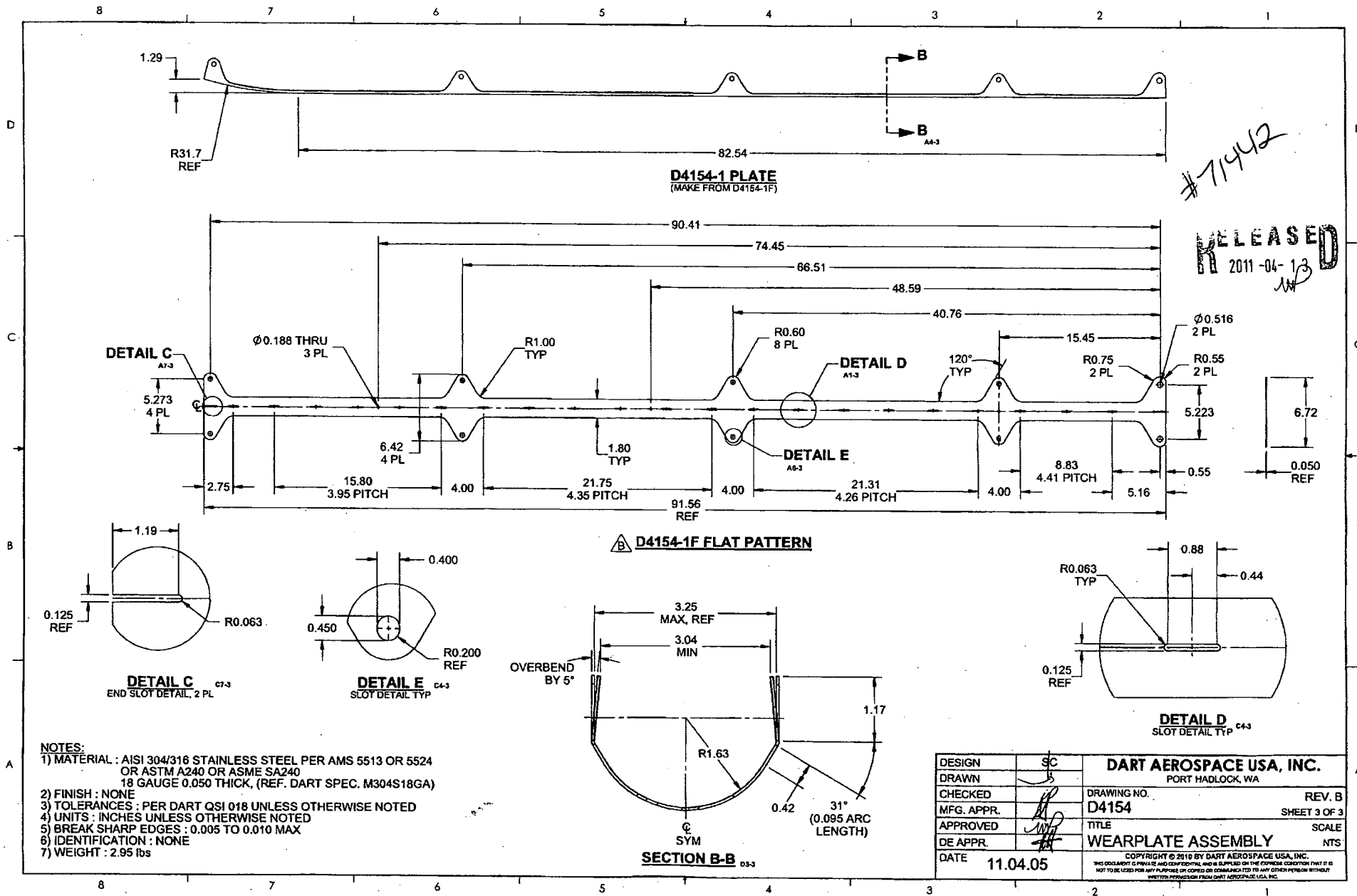
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